

Work Order ID 125411

Tuesday, October 07, 2014 10:43:17 AM

125411

Page 1

Item ID: D350-607-241

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Basket Clamp

Start Date: 9/26/14 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 10/06/14 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: MLS Date: 11-10-09 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
D350-607-1	A	

SMB MLS 1501-30 2

100 Document Control 0.00

100

DC

Doc.Control -USB or Paperwork

Memo

Photocopy bluefile & type labels per PPP D350-607-241
CHG001
Paperwork not req'd if packaged with basket

2x **DAS 46**
9-89

FEB 02 2015

110 Pick Kit 0.00

110

Packaging

Packaging

Memo

0.00

SMB
JAN 30 2015

2x **DAS 46**
9-89

120 QC4- 100% Inspect kits for completeness 0.00

120

QC

Quality Control

Memo

0.00

2x **DAS 46**
9-89

FEB 02 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 25%;">Skid-tube ☐</td> <td style="width: 25%;">Crosstube ☐</td> <td style="width: 25%;">Water Jet ☐</td> <td style="width: 25%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 125411***125411***

Page 2

Tuesday, October 07, 2014 10:43:18 AM

Item ID: D350-607-241

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Basket Clamp

Start Date: 9/26/14 Start Qty: 2.00

2

Cust Item ID:

Required Date: 10/06/14 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-607-241

Location: _____

PPP rev: _____

*PLC 6 12*DAS
06
9-89

FEB 03 2015

140

QC21 - Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

*MLS 1502-03**2-3*

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Tuesday, October 07, 2014 10:43:17 AM

Page 1

4

Work Order ID: 125411

125411

Parent Item: D350-607-241

D350-607-241

Parent Item Name: Basket Clamp

Start Date: 9/26/14

Required Date: 10/06/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC
as per ECN10-545 DD 10.04.16 verified by:EC
AS PER IIN REV.A DD VERF:JLM

IPP Rev:B

IPP REV:C 13.08.07

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2230-1		Manufactured	No			110	Each	537.0000	4	8			
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D2230-1

Mounting Lug

DAS

46

9-89

**

ShmB
JAN 30 2015

Location

Loc Qty

Loc Code

FG	4	
84136	4	
ST519	533	
101834	1	
110834	4	
113437	112	
115306	79	
116380	160	
116381	160	
116382	17	



DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Tuesday, October 07, 2014 10:43:17 AM

Work Order ID: 125411

125411

Parent Item: D350-607-241

D350-607-241

Parent Item Name: Basket Clamp

Start Date: 9/26/14

Required Date: 10/06/14

Start Qty: 2.00

Required Qty: 2.00

D2230-3

Manufactured No

110

Each

394.0000

4 8

**

Smb

JAN 30 2015

D2230-3

Mounting Lug

DAS

46

9-89

Location

Loc Qty

Loc Code

FG

7

109344

4

89045

3

ST519

227

108668

1

109344

2

114151

1

114921

4

116378

143

116379

76

ST521

160

123324

160

D2732

Manufactured No

110

f

887.8000

2 4

**

Smb

JAN 30 2015

D2732

Rubber Extrusion

DAS

46

9-89

Location

Loc Qty

Loc Code

ST410

0.25

107346

0.25

ST415

887.55

117118

887.55

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

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Equip/Tooling									
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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Tuesday, October 07, 2014 10:43:17 AM

Work Order ID: 125411

125411

Parent Item: D350-607-241

D350-607-241

Parent Item Name: Basket Clamp

Start Date: 9/26/14

Required Date: 10/06/14

Start Qty: 2.00

Required Qty: 2.00

AN4-15A

Purchased

No

110

Each

526.0000

8

16

AN4-15A

DAS

Bolt

46

9-89

**

SMB
JAN 30 2015

Location

Loc Qty

Loc Code

GA

100

120449

100

ST343

400

m129732

200

m130358

200

ST357

11

m127817

11

ST515

15

122141

4

m123525

6

m128978

5

M13BOS 16

NAS1149D0463J

Purchased

No

110

Each

4,366.000

16

32

NAS1149D0463.J

DAS

WASHER

46

9-89

**

SMB
JAN 30 2015

Location

Loc Qty

Loc Code

CA

472

M129682

472

ST277

3894

16941

8

M126221

20

M127813

6

M127904

16

M128591

44

M128995

1500

M129390

2300

M130799 32

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Tuesday, October 07, 2014 10:43:17 AM

Work Order ID: 125411

125411

Parent Item: D350-607-241

D350-607-241

Parent Item Name: Basket Clamp

Start Date: 9/26/14

Required Date: 10/06/14

Start Qty: 2.00

Required Qty: 2.00

MS21042L4

Purchased

No

110

Each

3,703.000

8

16

MS21042L4

Locknut

DAS

46

9-89

Smb
JAN 30 2015

Location

Loc Qty

Loc Code

ST007

12

121444

12

ST307

3691

111827

2

126275

5

m126015

12

m126275

27

m127255

63

m127376

9

m127813

821

m128300

69

m128798

658

m129472

525

m129934

1500

m130799

16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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6.0 PARTS LIST

6.1 D350-607-041/-041A/-043/-043A HELI-UTILITY-BASKET™

Qty -041	Qty -041A	Qty -043	Qty -043A	Qty -241	Part Number	Description
X					D350-607-041	HELI-UTILITY-BASKET
	X				D350-607-041A	HELI-UTILITY-BASKET
		X			D350-607-043	HELI-UTILITY-BASKET
			X		D350-607-043A	HELI-UTILITY-BASKET
1	1	1	1	X	D350-607-241	BASKET CLAMP KIT INSTALLATION
2	2	5	5		D2022-101	SPACER
1	1	1	1		D2221	BASKET BASE ASSEMBLY
				4	D2230-1	LUG
				4	D2230-3	CLAMP
1	1	1	1		D2258-200	LABEL
1	1	1	1		D2324	STRUT
1		1			D2332-041	PROP ASSEMBLY
1	1				D2512	BASKET LID ASSEMBLY
1	1	1	1		D2530	HANDLE WELDMENT
2	2	2	2		D2535	SPRING
2	2	2	2		D2537	BUSHING
				8	D2732-030	RUBBER CUSHION
2	2	2	2		D2931	BUMPER
		1	1		D2989-041	BASKET LID ASSEMBLY (OUTSIDE)
		1	1		D2989-043	BASKET LID ASSEMBLY (INSIDE)
	1				D350-607-141	AUTOMATIC LID OPENER INSTL
			1		D350-607-143	AUTOMATIC LID OPENER INSTL
2	2	2	2		AN3-16A	BOLT
2	2				AN4-7A	BOLT
5	5	5	5		AN4-12A	BOLT
		2	2		AN4-13A	BOLT
				8	AN4-15A	BOLT
1		7	5		AN4-22A	BOLT
1					AN4-24A	BOLT
4	4	4	4		AN5-17A	BOLT
2	2	2	2		MS20600AD4W3	RIVET (OR CR9163-4-3)
12	12	24	24	16	NAS1149D0463J	WASHER (OR AN960JD416)
2		2			NAS1149D0416J	WASHER (OR AN960JD416L)
4	4	4	4		NAS1149D0563J	WASHER (OR AN960JD516)
2	2	2	2		NAS1149DN832J	WASHER (AN960JD8)
		2	2		NAS1515H4	WASHER
4		4			AN970-4	WASHER
2	2	2	2		MS21042L3	NUT (OR MS21042-3)
9	7	14	12	8	MS21042L4	NUT (OR MS21042-4)
4	4	4	4		MS21042L5	NUT (OR MS21042-5)